

Work Order ID 66084

Thursday, February 03, 2011 3:17:44 PM



Page 1

Item ID: D3575-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MADate: 11-02-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3575

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3575 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessaryB 11-2-72

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-2-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

MA 11 02 08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

E. J. / 02/09 (2)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

ml 11 02 08 (2)

150



Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

PPD
66084

P. J. / 2/8 (2)

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Page 3

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Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/02/09 [Signature]

MF
11-02-09

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 3:17:40 PM

Page 1

Work Order ID: 66084

Parent Item: D3575-6

Parent Item Name: Cabin Floor Protector


Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	3,417.678	10.666	22.45474			
													
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

MAT

3417.6788

115261

886.6788

116236

2531

116236

1311-2-7

5

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 06084
Description: Cabin Floor Protector		Part Number: D3575-6
Inspection Dwg: D3575	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	✓		U1B02	
3.38	+/-0.030	3.38	✓		T1B01	
6.50	+/-0.030	6.50	✓		T	
26.13	+/-0.030	26.13	✓		T	
30.13	+/-0.030	30.13	✓		T	
2.00	+/-0.030	2.00	✓		T	
3.50	+/-0.030	3.50	✓		T	
14.25	+/-0.030	14.25	✓		T	
25.13	+/-0.030	25.13	✓		T	
29.38	+/-0.030	29.38	✓		T	
30.38	+/-0.030	30.38	✓		T	
31.50	+/-0.030	31.50	✓		T	
1.00	+/-0.030	1.00	✓		T	
4.38	+/-0.030	4.38	✓		T	
14.50	+/-0.030	14.50	✓		T	
16.00	+/-0.030	16.00	✓		T	
23.13	+/-0.030	23.13	✓		T	
26.88	+/-0.030	26.88	✓		T	
27.69	+/-0.030	27.69	✓		T	
1.00	+/-0.030	1.00	✓		T	
3.75	+/-0.030	3.75	✓		T	
9.63	+/-0.030	9.63	✓		T	
16.13	+/-0.030	16.13	✓		T	
28.06	+/-0.030	28.06	✓		T	
32.15	+/-0.030	32.15	✓		T	

Measured by: B	Audited by: M/M	Prototype Approval:	N/A
Date: 11-2-7	Date: 11-02-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	

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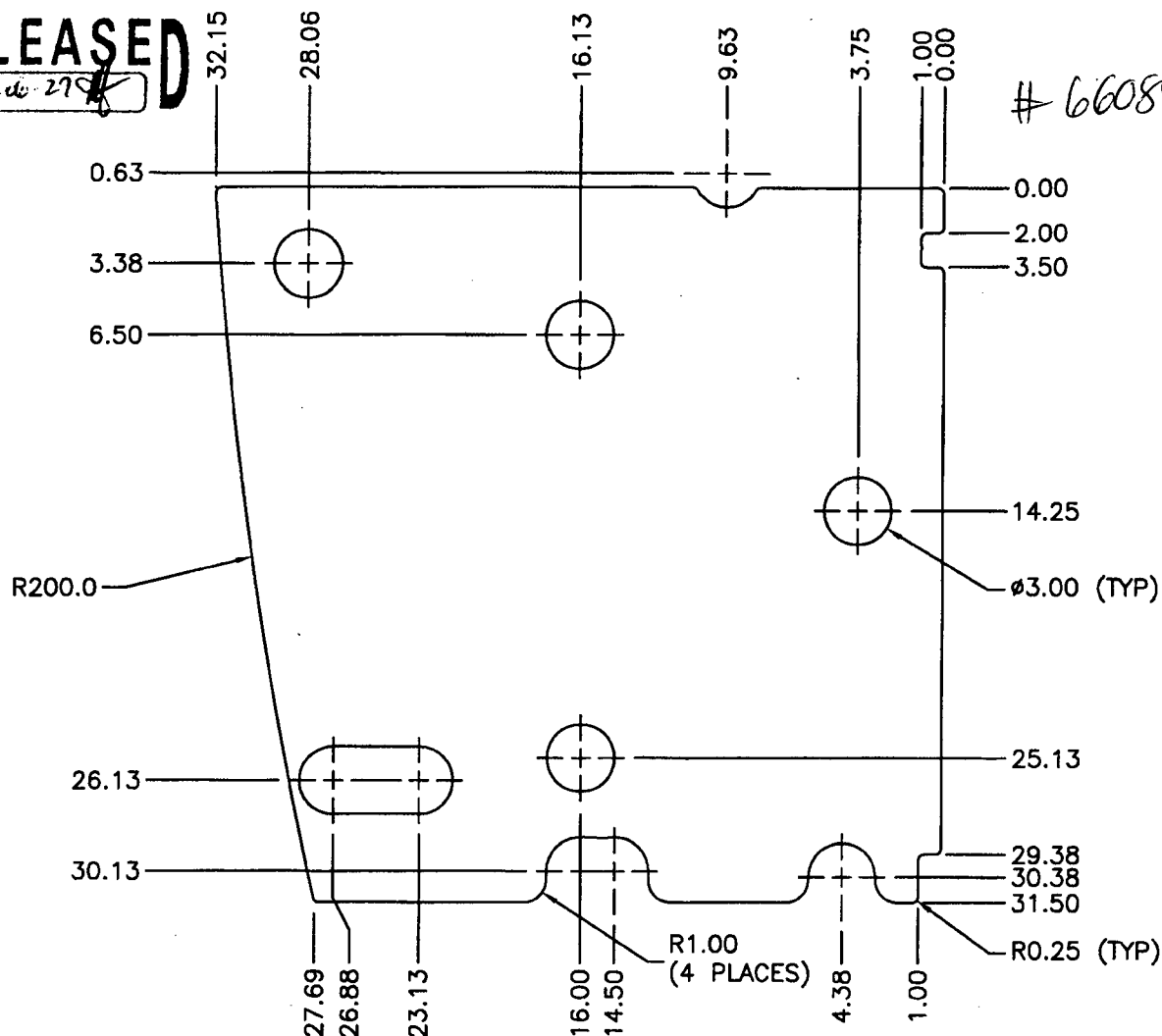
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DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07-06-278

D3575-5 CABIN FLOOR PROTECTOR (SHOWN)
D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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